

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023209**Date Inspected:** 30-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TA YARD, OBG 14E (NWIT # 08991)

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

SEG3019F-013

SEG3019H-038

SEG3019L-045

SEG3019N-022

SEG3019Q-1-103

SEG3019S-206

SEG3019V-007

SEG3019AX-034

This Quality Assurance (QA) Inspector observed the following work in progress:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

TA YARD

OBG Seg 14W:

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020AZ-242, 247, 252 and 257 [I-rib on Side Panel (SP) 3140F to Floor Beam (FB) 3344A, Complete Joint Penetration (CJP) weld at Panel Point (PP) 128.3]. The welder is identified as 067949 and was observed welding in 3G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

The FCAW process on weld joint no: SEG3020AB-016 [Deck Panel (DP) diaphragm of DP 3173A to Longitudinal Diaphragm (LD) 3050A, CJP weld at PP 127.5 to PP 128]. The welder is identified as 066695 and was observed welding in 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020AH-004 [SP 3144B to Edge Panel (EP) 3029A, CJP weld at PP 127.3 to PP 128]. The welder is identified as 066421 and was observed welding in 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020AH-002 [SP 3144B to EP 3029A, CJP weld at PP125 to PP127]. The welder is identified as 037932 and was observed welding in 2G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-P-2212-Tc-U4b-FCM-1.

The FCAW process on weld joint no: SEG3020K-003 [DP diaphragm of DP 3172A to DP diaphragm of DP 3173A, CJP weld at PP 127.3]. The welder is identified as 066881 and was observed welding in 3G position. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2233-ESAB.

Repair welding of weld joint no: SEG3020AQ-025 [Top anchorage plate (AP) PL3591A to SP 3144B, CJP weld in between PP 125 to PP126]. The welder is identified as 066361 and was observed welding in the 1G position. Welding process was identified as SMAW. ZPMC QC was identified as Mr. Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-1G(1F)-FCM-Repair-1. Repair welding was done as per Critical Welding Repair (CWR) Report: B-CWR 2923 Rev-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
